

SPECIAL PACKAGING INSTRUCTION

Form Approved -SS RJ
OMB No. 0704-0188

Public reporting burden for this collection of information is estimated to average 30 days per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503. Please do not return your form to either of these addresses.

1. PART OR DRAWING NO. (CAGE) NOMENCLATURE 12422745 (19207) AXLE ASSEMBLY, FRONT DRIVE STEERING, ABS			2. CODE INDENT 19207	3. SPI NO. AK14644568
4. NATIONAL STOCK NO. 2520-01-464-4568			5. DATE OF DRAWING 04-30-2002	6. REVISION
7. QUP 1 EA	8. ICQ NONE	9. UNIT PACK WT. (LB) 1784.5	10. UNIT PACK CU (CU. FT.) 71.121	11. UNIT PACK SIZE (INCHES) 101.0 X 36.0 X 33.8

		18. STEPS	19. REQD	20. DESCRIPTION
12. MILITARY PRESERVATION METHOD 20		1B		PRESERVATIVE: A-A-52465.
13. CLEANING MIL-STD-2073-1D, PROCEDURE 1		2C		PRESERVATIVE: MIL-PRF-2105 GRADE GO-80/90.
14. DRYING MIL-STD-2073-1D		3D		PRESERVATIVE: MIL-PRF-16173, GRADE 4.
15. PACKING		4E		PRESERVATIVE: MIL-PRF-10924.
a. LEVEL A MIL-STD-2073-1D AND NOTE L		5F		CLOSURE: NAS 847.
b. LEVEL B NOT APPLICABLE		6G		WRAP: MIL-B-121, TYPE II, GRADE A, CLASS 2.
16. MARKING MIL-STD-129 AND NOTE K		7H		CUSHIONING AND BLOCKING: MIL-STD-1186.
		8J	1	CONTAINER: MIL-B-26195 (MOD), STYLE A, TYPE II, GRADE I,
				CLASS 1, SIZE 98-7/8 X 33-9/16 X 25.

17. NOTES/DRAWING

A. QUALITY ASSURANCE PROVISIONS:

INSPECT THE PRESERVATION AND UNIT PACK IN ACCORDANCE WITH MIL-STD-2073-1. INSPECT PACKING IN ACCORDANCE WITH MIL-STD-1186 AND THE APPLICABLE CONTAINER SPECIFICATION.

B. REMOVE BRAKE DRUMS AND APPLY PRESERVATIVE TO ALL BARE METAL BRAKE COMPONENTS INCLUDING THE FINISHED SURFACE OF THE BRAKE DRUM. **NOTE: INSTALL BRAKE DRUMS ON AXLE AFTER PRESERVATIVE HAS THOROUGHLY DRIED.**

C. FILL AXLE DIFFERENTIAL OPERATING LEVEL WITH OPERATING FLUID. ROTATE BRAKE DRUMS TO PROVIDE PROTECTION TO THE INTERNAL PARTS OF THE AXLE ASSEMBLY AND SEAL ALL OPENINGS. ATTACH A TAG TO EACH END OF AXLE STATING **"RESERVOIRS ARE FILLED WITH MIL-PRF-2105 GRADE GO-80/90 OPERATING LUBRICANT".**

D. APPLY PRESERVATIVE TO ALL UNPAINTED EXTERIOR SURFACES EXCEPT THE U-JOINT YOKE. APPLY PRESERVATIVE TO UNPAINTED SURFACES OF BRACKET "C".

E. APPLY PRESERVATIVE THROUGH ALL GREASE FITTINGS. APPLY PRESERVATIVE TO UNPAINTED SURFACES OF THE U-JOINT YOKE INCLUDING THE THREADED HOLES. WRAP WITH MIL-B-121, TYPE II, GRADE A, CLASS 2 AND SECURE WITH PPP-T-60, TYPE III, CLASS 1 TAPE. **NOTE: MANUFACTURER'S PLASTIC PROTECTIVE CAPS ARE ACCEPTABLE AS AN ALTERNATIVE TO THE USE OF WRAP.**

F. PLUG OR CAP ALL OPEN PORTS. **NOTE: MANUFACTURER'S PLUGS AND CAPS ARE ACCEPTABLE.**

G. COMPLETELY WRAP EACH WHEEL STUD AND SECURE WITH PPP-T-60, TYPE III, CLASS 1 TAPE. **NOTE: MANUFACTURER'S CAPS ARE ACCEPTABLE. NOTE: PREPARE A TAG AS FOLLOWS: "STUDS HAVE BEEN PRESERVED WITH MIL-PRF-16173 GRADE 4 PRESERVATIVE. REMOVE PRIOR TO USE". ATTACH TAG TO ONE OF THE WHEEL STUDS.**

H. FABRICATE RUBBING STRIPS "A", BLOCKS "B", "D", AND BRACKETS "C" IN ACCORDANCE WITH CHART ON PAGE 2 AND FIGURE 1, FIGURE 2, FIGURE 3 AND FIGURE 4 ON PAGE 3.

I. NOTE "I" IS NOT USED.

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Pad or Block Number	MIL-STD-731, Lumber (Nominal Size)	Critical Dimensions (Inches)			QTY	COMMENTS
		L	W	D		
A	4 X 4	29			4	FABRICATE IN ACCORDANCE WITH FIGURE 1 ON PAGE 3.
B	SEE COMMENTS				2	FABRICATE IN ACCORDANCE WITH FIGURE 2 ON PAGE 3.
C	BRACKET "C" SEE COMMENTS				2	MATERIAL 3/8 1018 STEEL PLATE. FABRICATE IN ACCORDANCE WITH FIGURE 3 ON PAGE 3.
D	SEE DIMENSIONS	33 - 1/2	4 - 1/4	3 - 1/2	2	FABRICATE IN ACCORDANCE WITH FIGURE 4 ON PAGE 3.

HARDWARE

NUMBER	DESCRIPTION	SIZE	QTY	COMMENTS
1	CARRIAGE BOLTS	3/8 INCH X 6 INCH	4	COMERCIAL QUALITY STEEL WITH COMERCIAL QUALITY ZINC PLATING IS ACCEPTABLE.
2	CARRIAGE BOLTS	3/8 INCH X 9 INCH	8	
3	CARRIAGE BOLTS	1/2 INCH X 9 INCH	4	
4	CARRIAGE BOLTS	3/8 INCH X 14 INCH	4	
5	CARRIAGE BOLTS	1/2 INCH X 10 INCH	4	
6	NUTS	3/8 INCH NC	16	LOOSENING OF THE INSTALLED NUTS, USED IN THE SECURING OF BLOCKING AND BRACING, AND ON ANCHOR BOLTS, SHALL BE PREVENTED BY EITHER NICKING THE EXPOSED THREADS OF THE BOLTS; APPLYING PAINT, ASPHALTUM OR MIL-PRF-16173, GRADE 1 PRESERVATIVE.
7	NUTS	1/2 INCH NC	8	
8	FLAT WASHERS	3/8	40	
9	FLAT WASHERS	1/2	8	
10	LOCKWASHERS	1/2	8	
11	LOCKWASHERS	3/8	16	
12	LAG BOLTS	3/8 INCH X 3 INCH	24	
13	FLAT WASHERS	3/4	4	

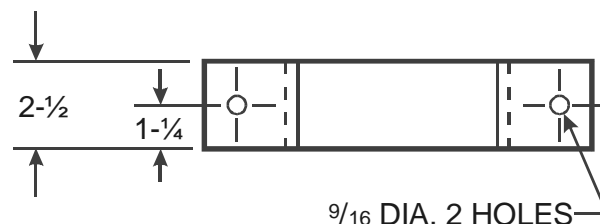
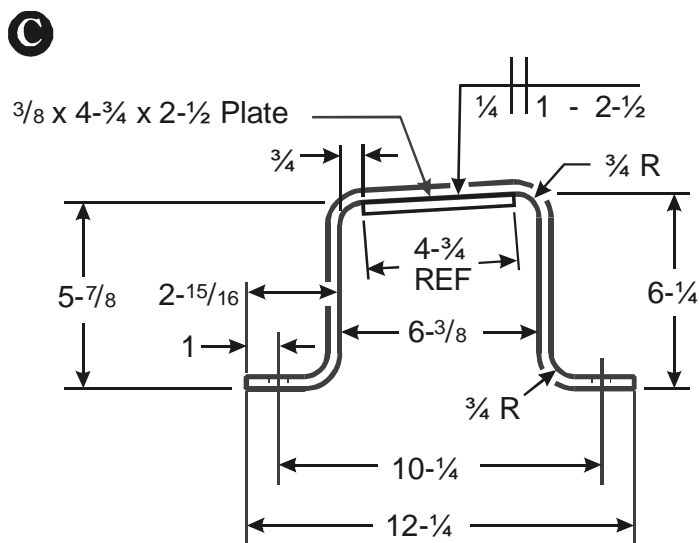
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FIGURE 3



3/8 1018 STL PLATE

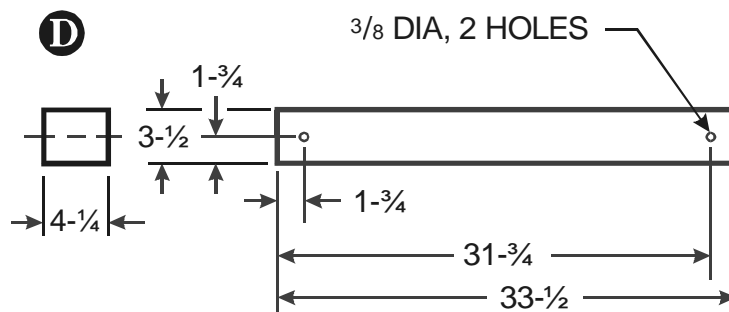
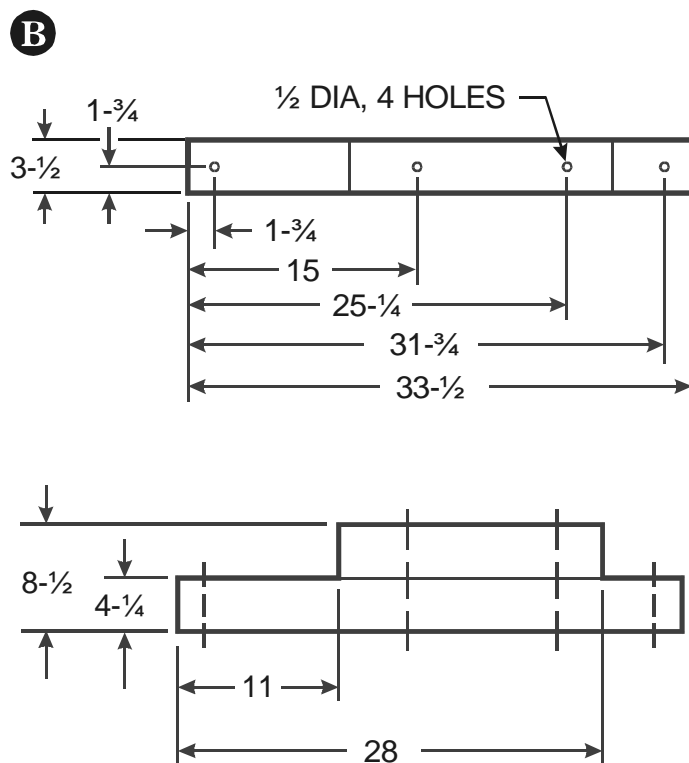


FIGURE 4

All dimensions are in inches.
All dimensions are actual.
All holes are dimensioned to center.

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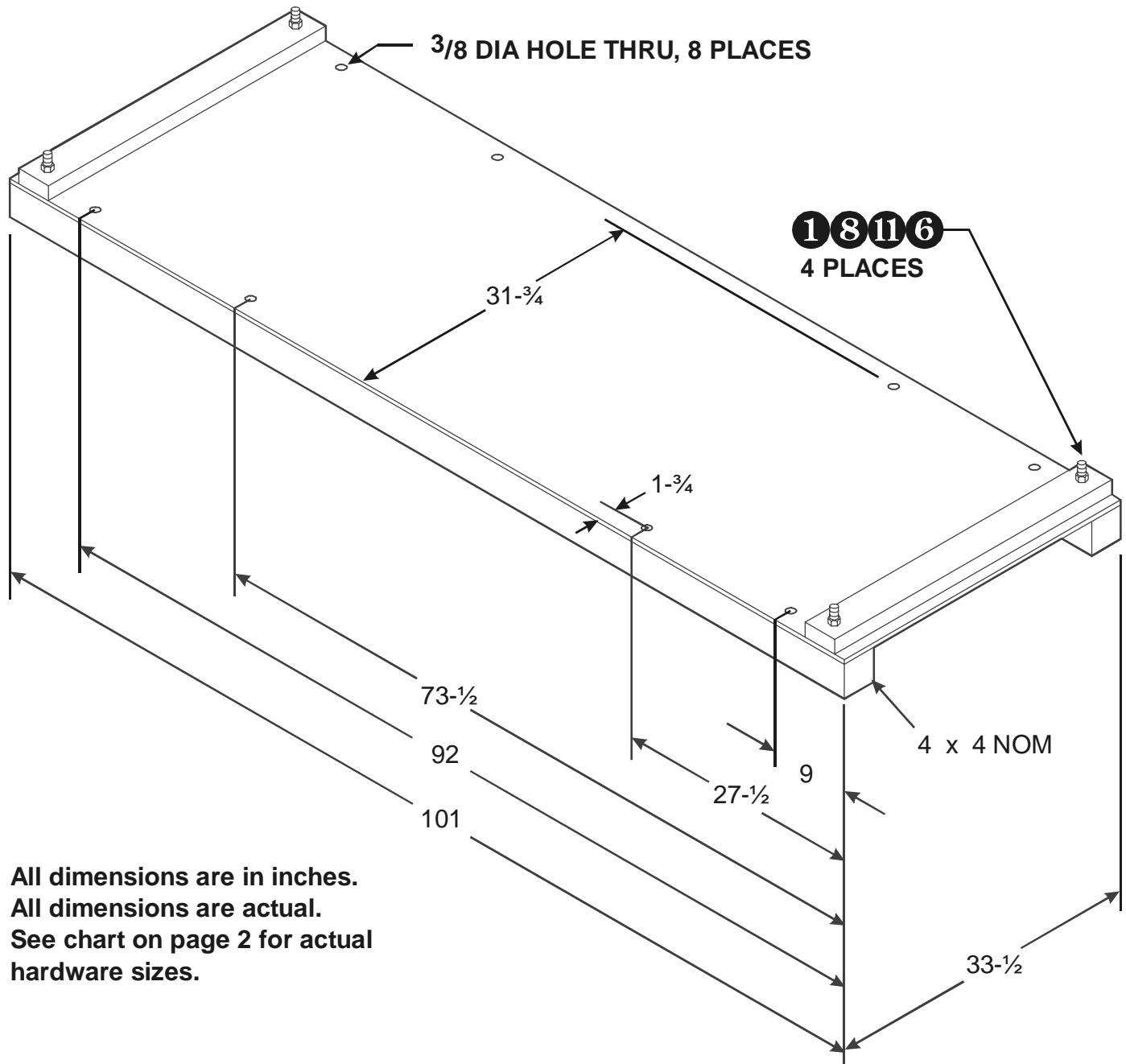
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J. FABRICATE MIL-B-26195 BASE USING HARDWARE FROM CHART ON PAGE 2 AND AS SHOWN IN FIGURE 5 BELOW.



All dimensions are in inches.
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See chart on page 2 for actual
hardware sizes.

FIGURE 5

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NOTE "J" CONTINUED.

SECURE RUBBING STRIPS "A" TO SKID USING HARDWARE FROM CHART ON PAGE 2 AND AS SHOWN IN FIGURE 6 BELOW.

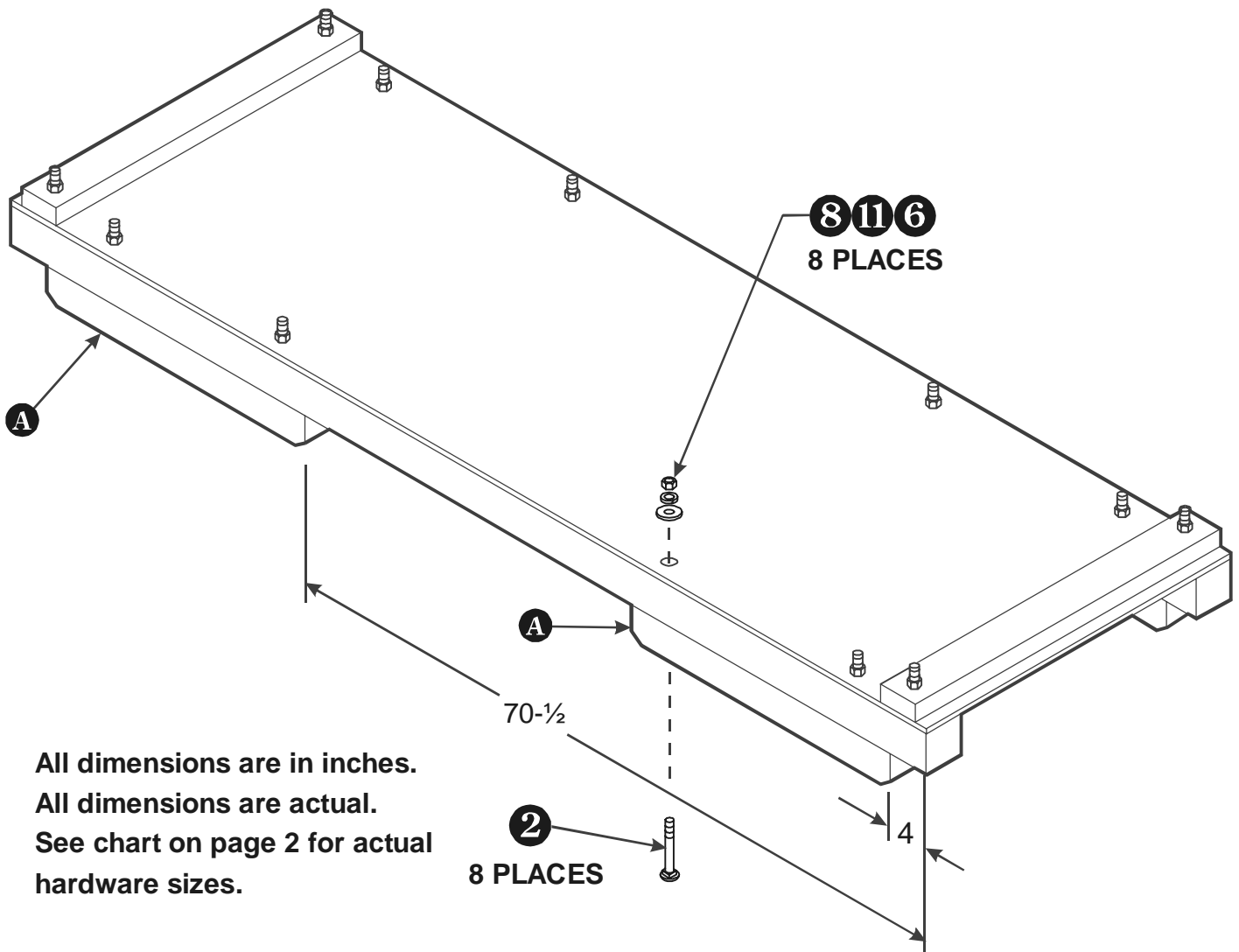


FIGURE 6

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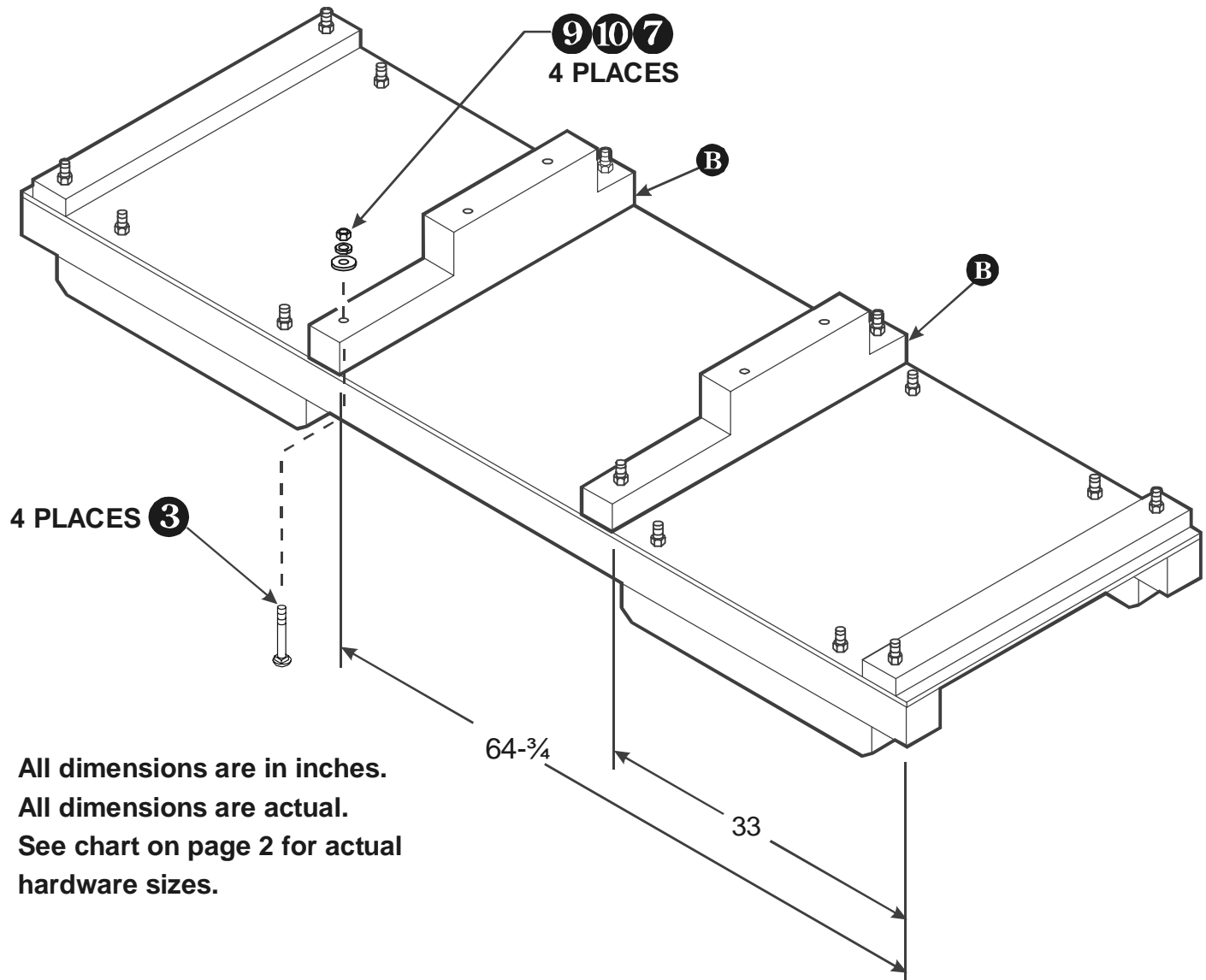
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NOTE "J" CONTINUED.

PLACE BLOCKS "B" ON BASE AS SHOWN IN FIGURE 7 BELOW. TACK BLOCKS "B" IN PLACE AS SHOWN IN FIGURE 7 BELOW. USING BLOCKS "B" AS A TEMPLATE, MATCH DRILL EIGHT (8) 1/2 INCH HOLES THROUGH BASE AS SHOWN IN FIGURE 7 BELOW. SECURE BLOCKS "B" TO BASE USING HARDWARE FROM CHART ON PAGE 2 AND AS SHOWN IN FIGURE 7 BELOW.



All dimensions are in inches.
All dimensions are actual.
See chart on page 2 for actual
hardware sizes.

FIGURE 7

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PLACE BLOCKS "D" ON SKID AS SHOWN IN FIGURE 8 BELOW. TACK BLOCKS "D" IN PLACE AS SHOWN IN FIGURE 8 BELOW.
USING BLOCKS "D" AS A TEMPLATE, MATCH DRILL FOUR (4) 3/8 HOLES THROUGH SKID AND RUBBING STRIP "A" AS SHOWN IN FIGURE 8 BELOW.
SECURE BLOCKS "D" TO SKID USING HARDWARE FROM CHART ON PAGE 2 AND AS SHOWN IN FIGURE 8 BELOW.

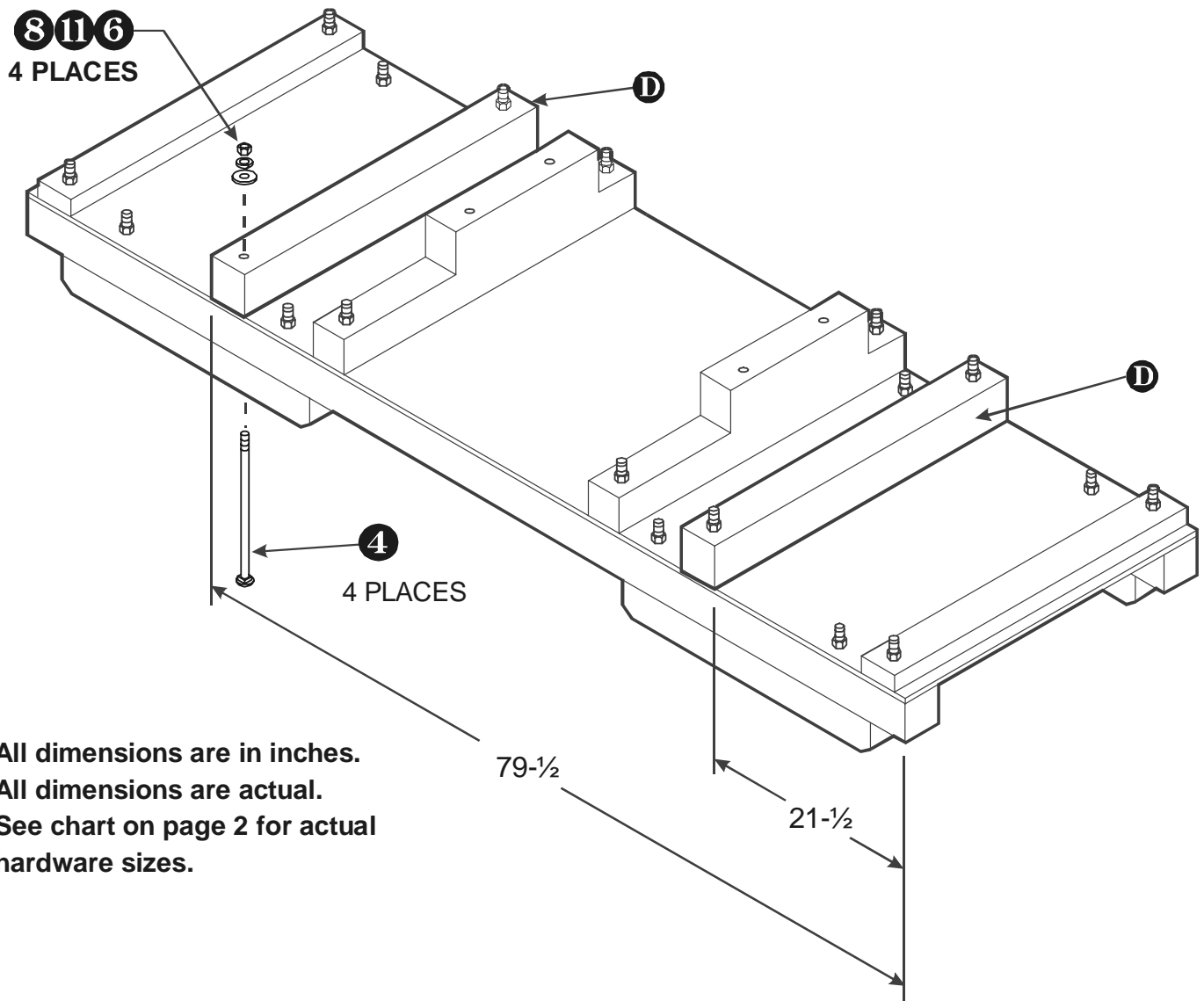


FIGURE 8

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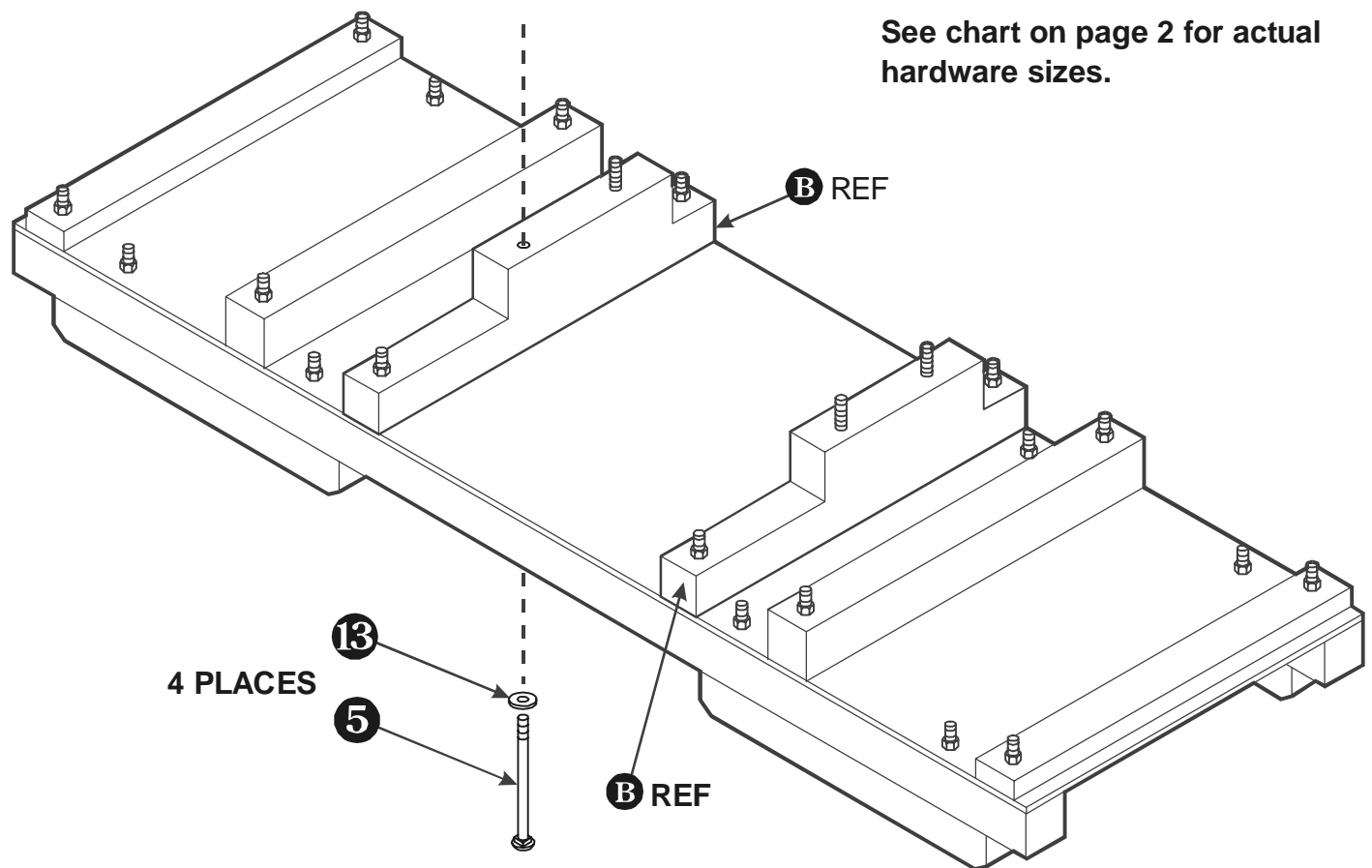
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NOTE "J" CONTINUED.

INSERT FOUR (4) EACH CARRIAGE BOLTS (NUMBER 5) WITH FOUR (4) EACH FLATWASHERS (NUMBER 13) THROUGH MOUNTING HOLES IN BLOCKS "B" AS SHOWN IN FIGURE 9 BELOW.



See chart on page 2 for actual hardware sizes.

FIGURE 9

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PLACE BARRIER MATERIAL MIL-B-121, TYPE II, GRADE A, CLASS 2, SIZE 6 X 24, TWO (2) EACH, AROUND AXLE AND MOUNTING PADS AND SECURE WITH PPP-T-60, TYPE III, CLASS 1 TAPE AS SHOWN IN FIGURE 10 BELOW. **NOTE: BOTH MOUNTING PADS SHOULD BE WRAPPED.**

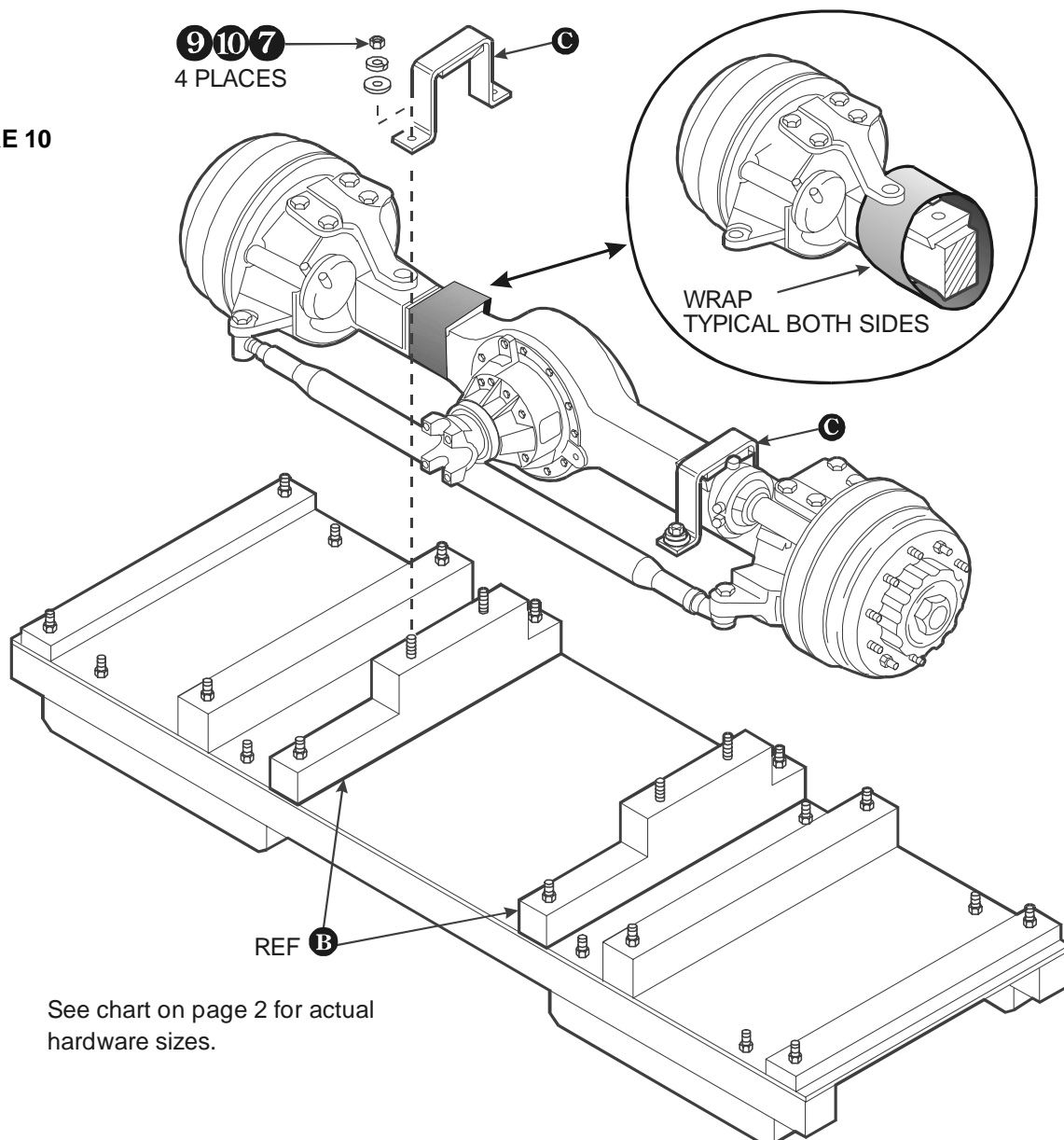
PLACE AXLE ON SKID AND CENTER ON BLOCKS "B" AS SHOWN IN FIGURE 10 BELOW AND IN FIGURE 11 ON PAGE 10.

PLACE BRACKETS "C" OVER MOUNTING PADS AND SECURE WITH HARDWARE FROM CHART ON PAGE 2 AND AS SHOWN IN FIGURE 10 BELOW AND FIGURE 11 ON PAGE 10.

NOTE: NUTS FOR HOLD DOWN BRACKETS SHOULD BE TORQUED TO 70 FOOT POUNDS.

NOTE: THE BRACKET IS FABRICATED WITH AN ANGLE. THE 5 - 7/8 INCH SIDE OR THE SHORT SIDE OF THE BRACKET SHOULD BE POSITIONED TO THE BACK SIDE OF AXLE (TOWARD THE TIE ROD).

FIGURE 10



See chart on page 2 for actual hardware sizes.

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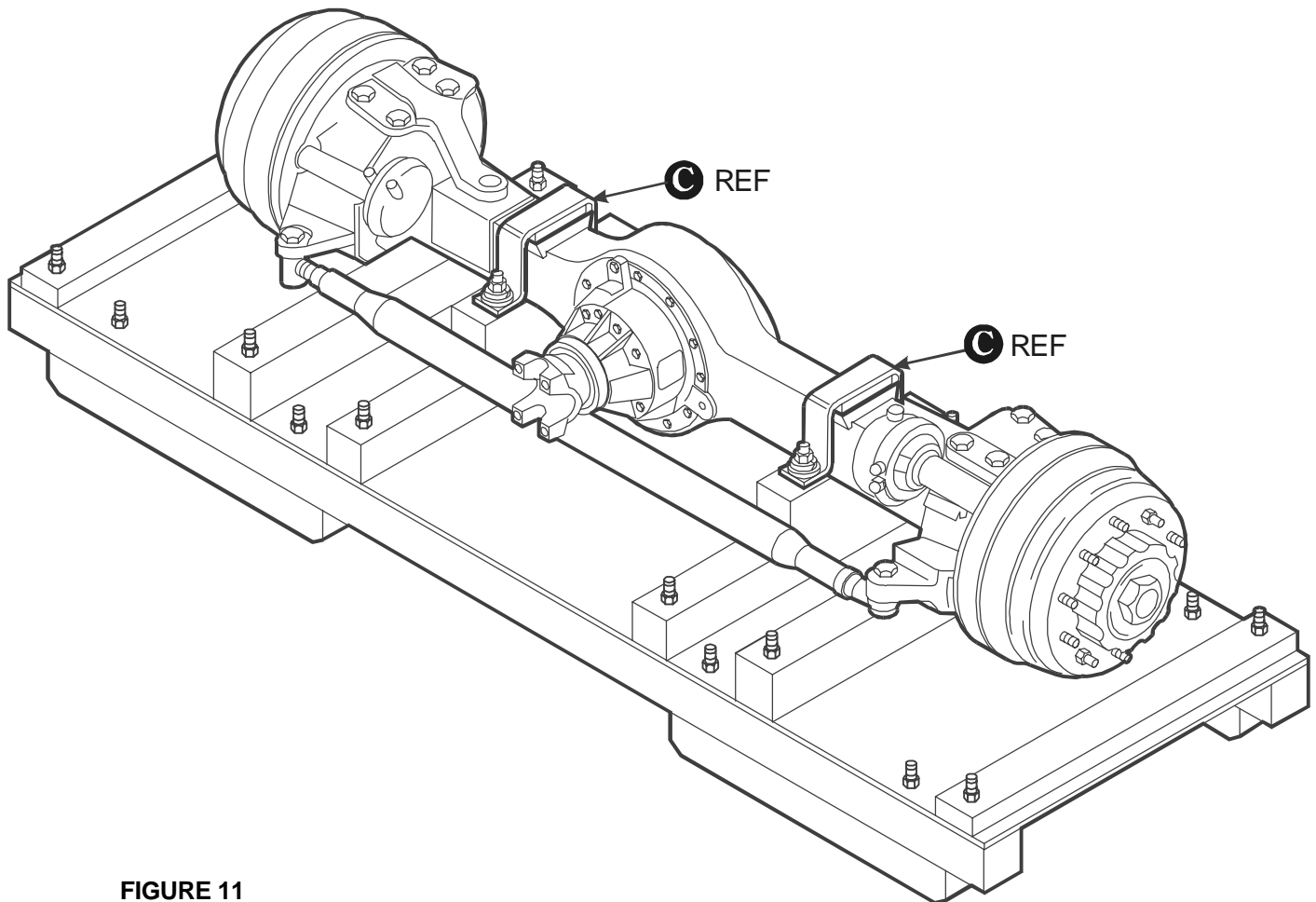
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FIGURE 11

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NOTE "J" CONTINUED.

FABRICATE MIL-B-26195 MODIFIED HOOD WITH JOIST SUPPORTS, VERTICAL JOIST SUPPORTS, AND LATERAL JOIST SUPPORTS USING NOMINAL 2 X 4 LUMBER COMFORMING TO MIL-STD-731. LOCATE CLEATS, JOIST SUPPORTS, AND VERTICAL JOIST SUPPORTS AS SHOWN IN FIGURE 12 BELOW. **NOTE: CONTAINER SHALL CONSTRUCTED WITH VENTILATION HOLES, DRAIN HOLES, AND CORNER STRAPS AS SPECIFIED BY MIL-B-26195.**

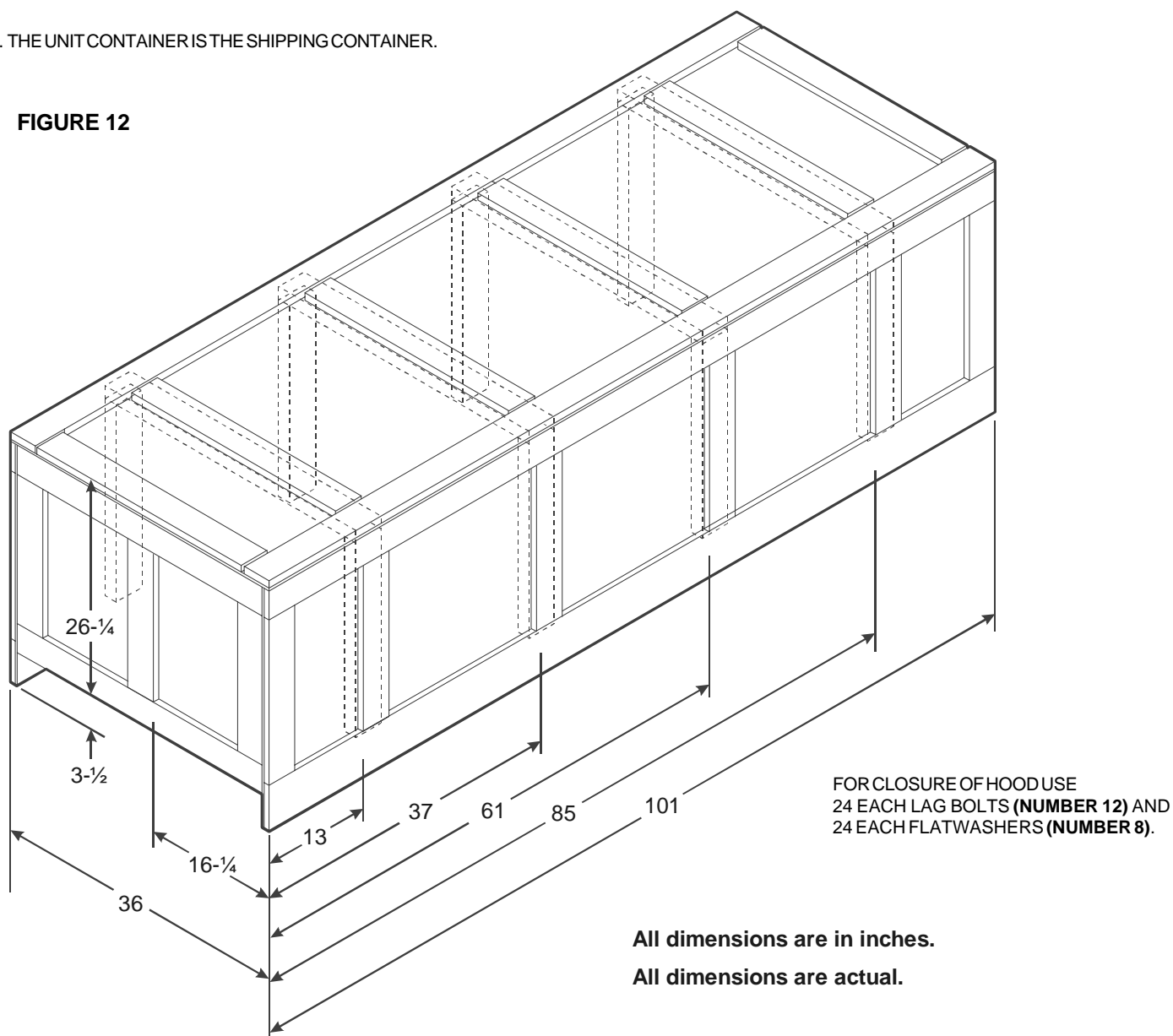
PLACE HOOD ON SKID AND SECURE USING 24 EACH LAG BOLTS (NUMBER 12) AND 24 EACH FLAT WASHERS (NUMBER 8).

K. MARK CONTAINER WITH 1 INCH LETTERS, ON BOTH SIDES AND ENDS: "REUSABLE CONTAINER DO NOT DESTROY."

CAUTION! LIFT BY BASE ONLY. TO OPEN, REMOVE BOTTOM LAG BOLTS".

L. THE UNIT CONTAINER IS THE SHIPPING CONTAINER.

FIGURE 12



All dimensions are in inches.

All dimensions are actual.